

Date: Wednesday, 12/11/2008 1:38:27 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 43366	
Estimate Number : 13264	
P.O. Number :	Part Number : D3777041
This Issue : 12/11/2008 S.O. No. :	Drawing Number : D3777 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 39490	Material :
Written By :	Due Date : 05/12/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 08.11.12</u>	
Comment : Est Rev:A new issue 08-05-26 DD verified by:EC Est Rev:B 08-10-20 revA as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S22GA	304/316 .032 Sheet
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Comment: Qty.: 0.0210 sf(s)/Unit Total : 0.2100 sf(s)
 304/316 .032 Sheet
 Batch: 109057 1B 8-11-17

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3777-1
 Dwg Rev: A
 Prog Rev: 1 1B 8-11-17
 2-Deburr if necessary 1B 8-11-17

(12)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Sosulie (X12)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1- Deburr any rough edges
 2- Form as per Dwg D3777

SB 08/12/02

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:38:27 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 43366

Part Number: D3777041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/03 (12)

7.0

D2182B013

Rubber cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Rubber Cushion
batch: B42737

08/12/03

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble rubber cushion as per dwg D3777

08/12/03 (12)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/03 (12)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST118

08/12/03 (12)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/03

Job Completion



MF 08-12-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

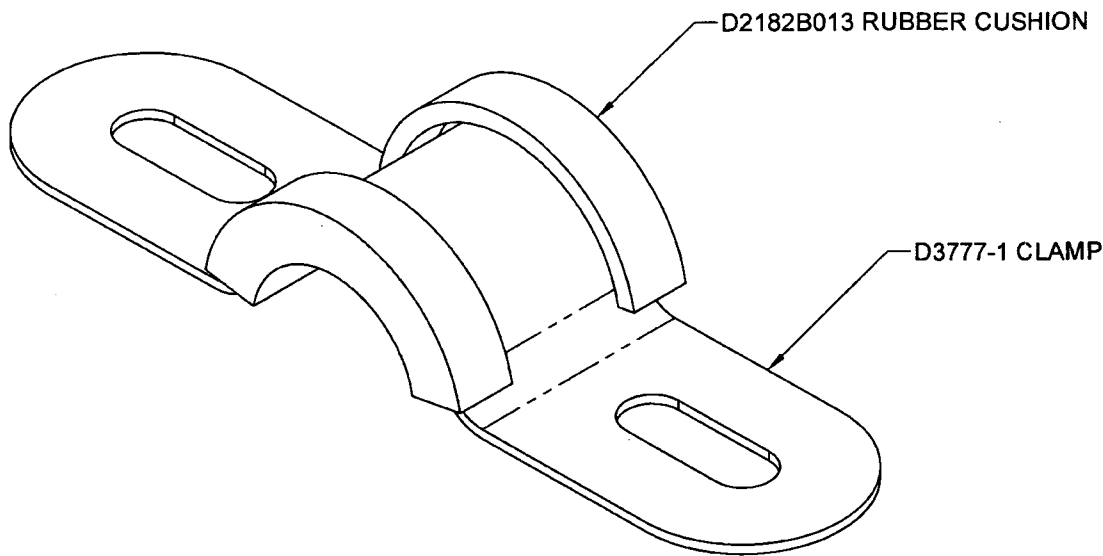
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	P/N	DESCRIPTION
X	D3777-041	CLAMP
1	D3777-1	CLAMP
1	D2182B013	RUBBER CUSHION



D3777-041 CLAMP

NOTES:

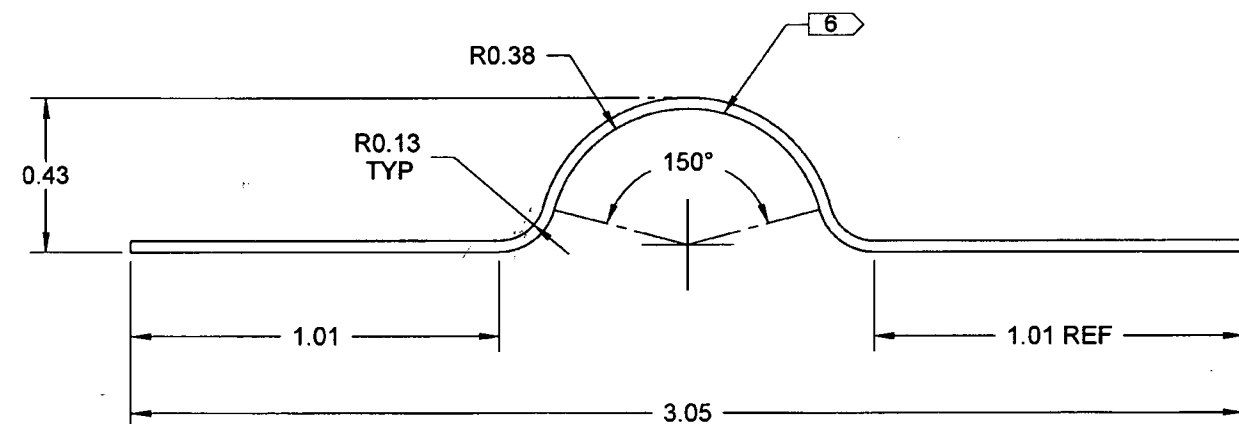
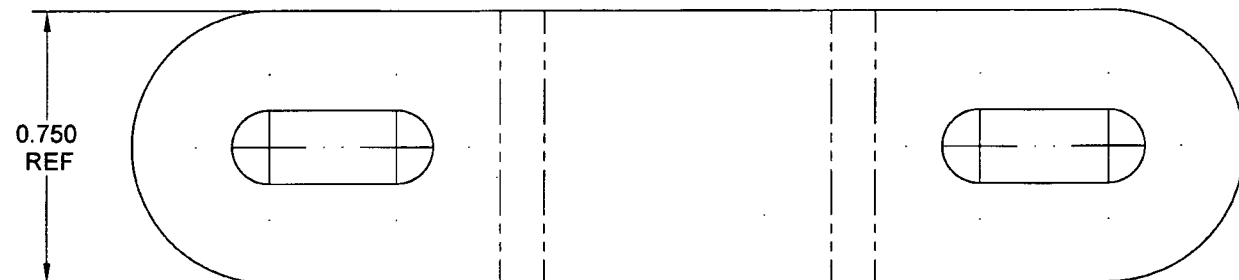
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

A	NEW ISSUE		CP	08.04.25
REV.	DESCRIPTION		BY	DATE
DESIGN	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	GP			
CHECKED	PH	DRAWING NO.	REV. A	
MFG. APPR.	MS	D3777	SHEET 1 OF 3	
APPROVED	MS	TITLE	SCALE	
DE APPR.	TH	CLAMP	NTS	
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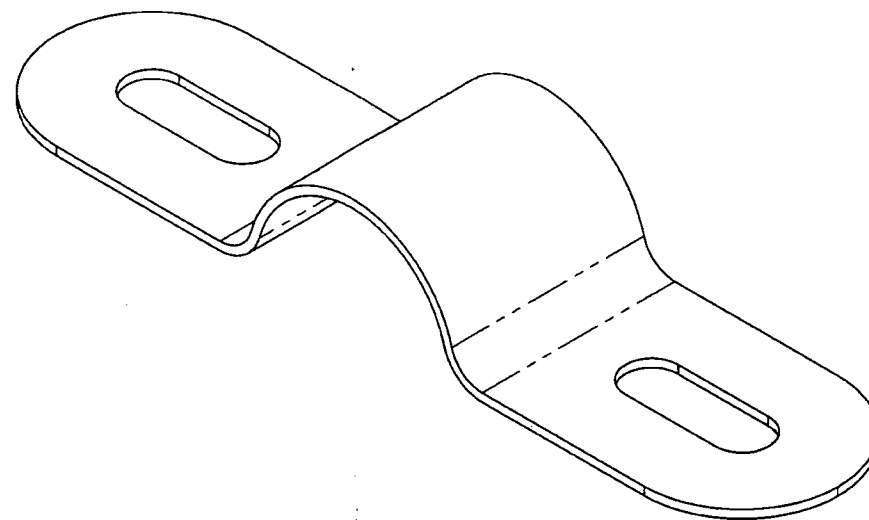
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WORK ORDER
NO. 43366

8 7 6 5 4 3 2 1



D3777-1 CLAMP



NOTES:

- 1) MATERIAL: MAKE FROM D3777-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3777-1" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 0.02 lbs

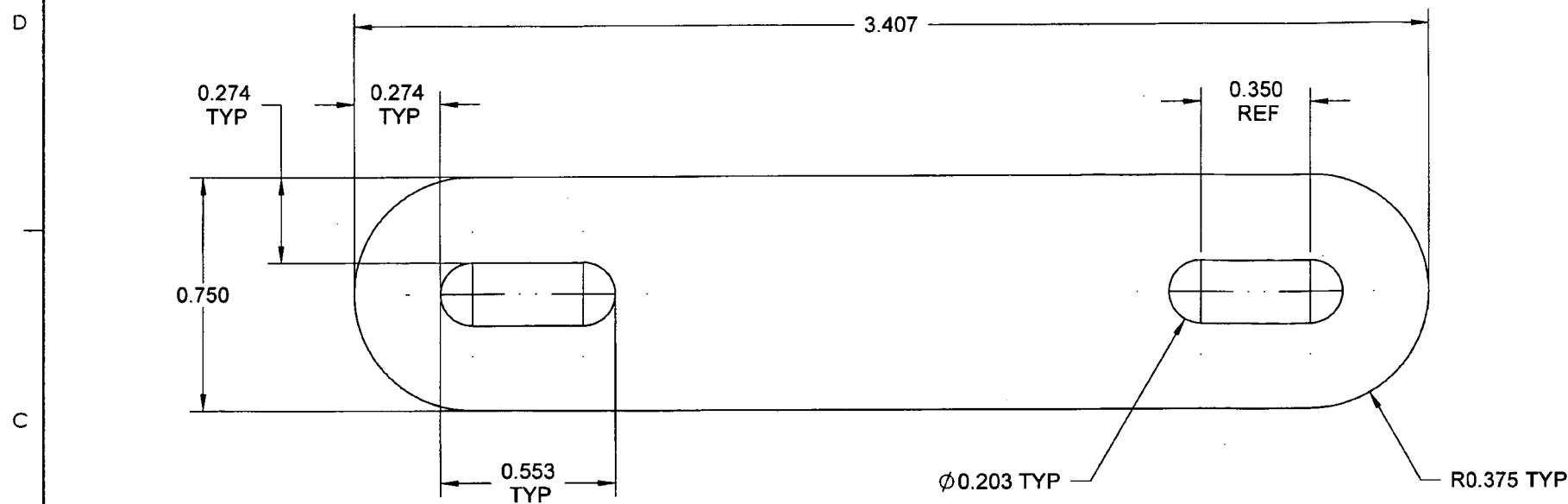
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08-10-15 JEP

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CHECKED	PH	DRAWING NO.	REV. A
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D3777-1F CLAMP

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 0.031 THICK (REF DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

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CHECKED	PH	DRAWING NO.	REV. A
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08.10.15/1P

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